

Work Order ID 110073

\*110073\*

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December-17-13 9:07:35 AM

Item ID: D2721-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: 206B Step Ass'Y

Start Date: 12/17/13 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan: MJSDate: 13-12-19

Tooling:

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2721

Rev C

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2721-2 using D2622 extrusion as per Dwg D2721  
Deburr and bevel ends for welding

2 0 AK  
14.01.14

110

0.00

\*110\*

Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT  
followed by Jig DT

A/R AL Rod

Batch:

125127

Grind end cap welds flush

2 0 AK  
14.01.22

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Stop \*NR2\*

0.00

(2) 14-01-29

(2) 14-01-29

2 7/8, 44.29

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** 206B Step Ass'Y

**Start Date:** 12/17/13      **Start Qty:** 2.00      **\*2\***

**Cust Item ID:**

**Required Date:** 12/17/13      **Req'd Qty:** 2.00      **\*~\***

**Customer:**

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop** **\*NR2\***

[illegible]

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Item ID: D2721-042 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: 206B Step Ass'Y  
Start Date: 12/17/13 Start Qty: 2.00 \*2\* Cust Item ID:  
Required Date: 12/17/13 Req'd Qty: 2.00 \*2\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
*180*						2	1402-04		DAS 9 9-89
QC	Memo	0.00							
Quality Control									
190	Chemical Conversion Coat per QSI005 4.1	0.00							
*190*						2	141-24		
HandFinish	Memo	0.00							
Hand Finishing									
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*200*						2	141-24		DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:10 OVEN TEMPERATURE: 320° FINISH TIME: 1:40								

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Item ID: D2721-042 Accept **\*N19000040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: 206B Step Ass'Y  
Start Date: 12/17/13 Start Qty: 2.00 **\*2\*** Cust Item ID:  
Required Date: 12/17/13 Req'd Qty: 2.00 **\*2\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC3- Inspect Part Finish	0.00							
<b>*210*</b>									
QC	Memo	0.00				2x	1	ll	14/02/04
Quality Control									
220	Wing Walk as per dwg QSI005 4.4 Batch <u>111281002</u>								
<b>*220*</b>									
HandFinish	Memo	0.00				2x	1	ll	14/02/04
Hand Finishing									
230	QC3- Inspect Part Finish	0.00							
<b>*230*</b>									
QC	Memo	0.00				2			
Quality Control									

DAS  
27  
3-89  
14/2/11

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Item ID: D2721-042 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: 206B Step Ass'Y  
 Start Date: 12/17/13 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 12/17/13 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location: _____	0.00							
*240*		0.00							DAS
Packaging	Memo								6
Packaging									89
250	QC21- Final Inspection - Work Order Release	0.00							
*250*		0.00							
QC	Memo								
Quality Control									

14-02-13  
 14-02-12

# Picklist Print

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Work Order ID: 110073  
 Parent Item: D2721-042  
 Parent Item Name: 206B Step Ass'Y

Start Date: 12/17/13 Required Date: 12/17/13  
 Start Qty: 2.00 Required Qty: 2.00

Comments: IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing walk DD 10.02.24  
 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	98.3900	1	2		Ac 14.01.14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				HALL		78							
				105575		78							
				WA003		20.39							
				101765		7.92			101765 → (2)				
				81507		4							
				89750		7.87							
				98024		0.6							
D2734 Step End Plate		Manufactured	No			110	Each	219.0000	1	2		14.01.30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		219			2				
				105712		137							
				80682		6							
				84563		10							
				91761		6							
				99709		60							
D2734 Step End Plate		Manufactured	No			160	Each	219.0000	1	2		14.01.30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		219			2				
				105712		137							
				80682		6							
				84563		10							
				91761		6							
				99709		60							

# Picklist Print

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Work Order ID: 110073

Parent Item: D2721-042

Parent Item Name: 206B Step Ass'Y

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 2.00

Required Qty: 2.00

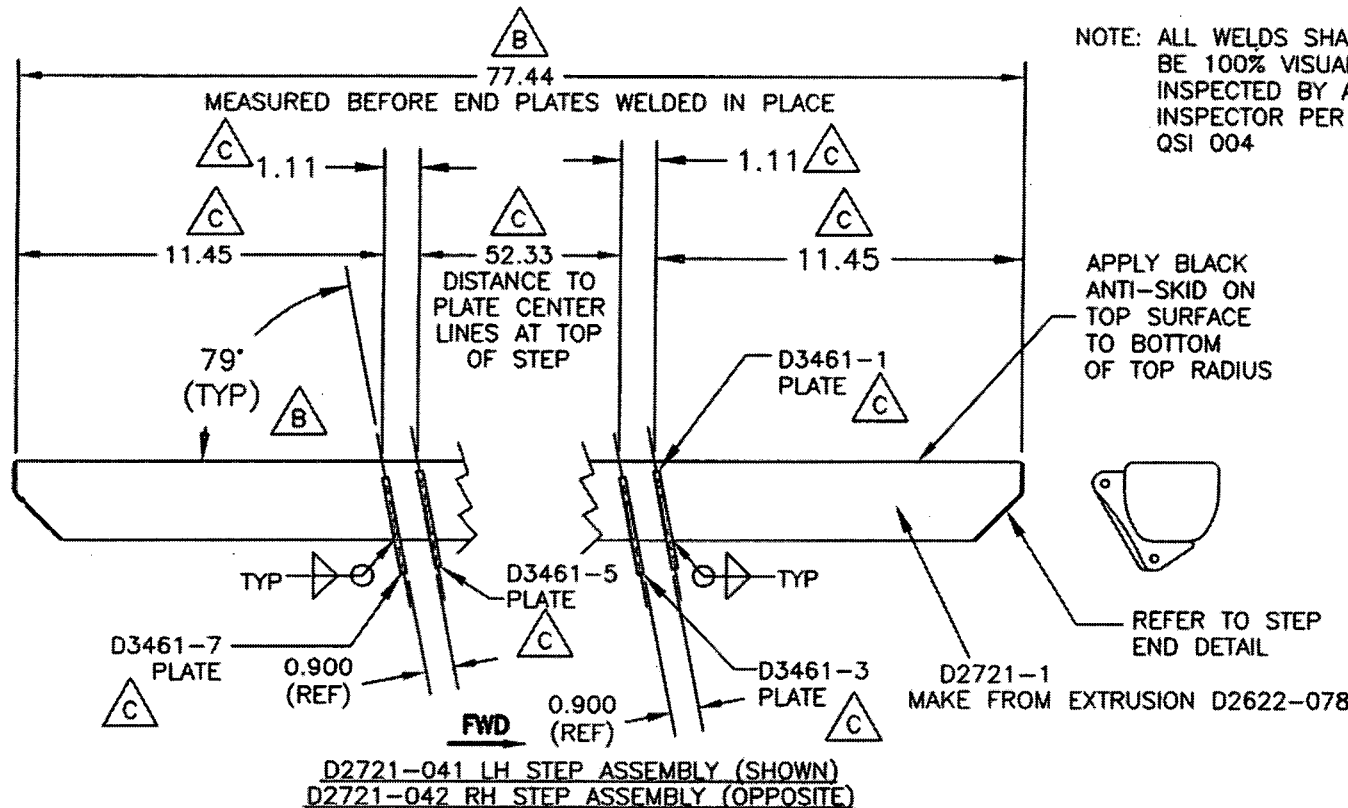
D3461-1	Manufactured	No	110	Each	30.0000	1	2	<u>14.01.22</u>
Mounting Plate								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA003	30				
			<u>58756</u>	30			<u>2</u>	
D3461-3	Manufactured	No	110	Each	2.0000	1	2	<u>14.01.22</u>
Mounting Plate								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA003 <u>B103090</u>	2			<u>2</u>	
			<u>76232</u>	2				
D3461-5	Manufactured	No	110	Each	3.0000	1	2	<u>14.01.22</u>
Mounting Plate								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA003 <u>B103090</u>	3			<u>1</u>	
			<u>33862</u>	3				
D3461-7	Manufactured	No	110	Each	5.0000	1	2	<u>14.01.22</u>
Mounting Plate								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA003	5			<u>2</u>	
			<u>33863</u>	5				

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Shop Packet Print

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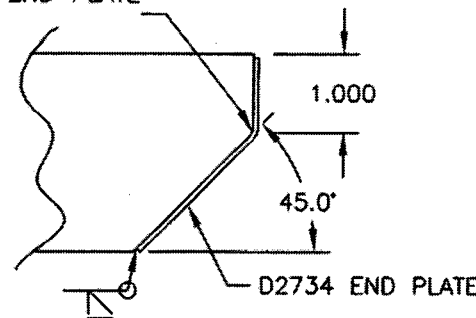
ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

#### D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X	X	D2721-041	LH STEP ASSEMBLY
		D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

#### D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



TYPICAL STEP END DETAIL

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

RELEASED  
05.11.14

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	D2721	206B STEP ASSEMBLY
		NEW ISSUE		
		REVISED TOLERANCES, 53.44 WAS 54.0		
		RE-DESIGN, ADD D3461-1/-3/-5/-7		
		SCALE		
		NTS		

DART

110073  
ML5  
13-12-19